

Date: Friday, 05/09/2008 10:07:52 AM
 User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: CLEVIS
Job Number	: 41858		
Estimate Number	: 10574		
P.O. Number	:	Part Number	: D34531
This Issue	: 05/09/2008 S.O. No. :	Drawing Number	: D3453 REV A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: // Type : MACHINED PARTS	Drawing Revision	: A
Previous Run	: 34995	Material	: A
Written By	:	Due Date	: 12/09/2008
Checked & Approved By	: <u>00089.05</u>	Qty:	12
Comment	: A 05.09.27 New issue EC	Um:	Each

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304R1250	304 round bar 1.250
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Comment: Qty.: 0.2880 f(s)/Unit Total: 2.3040 f(s)
 Material: AISI 304 SS Round Bar Ø1.250
 (M304R1.250)
 Batch: M105812

3.352 A

2.0	HARDINGE	HARDINGE CNC LATHE SMALL
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Comment: HARDINGE CNC LATHE SMALL
 1-Turn as per Folio FA577 Rev: A & Dwg D3453 Rev: A
 2- Deburr as per dwg D3453

SA 08/09/16

(12)

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SA 08/09/16

(12)

4.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1
 1-Mill as per Folio FA577 Rev: A & Dwg D3453 Rev: A
 2- Deburr as per dwg 3453

JL 08/09/20

(11)

(12)

5.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

JL 08/09/20

(10)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3453-1 PAR #: N/A Fault Category: Prod / Machined Parts NCR: Yes No DQA: D Date: 08/10/09
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR: 41858		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08/09/20	4	2 part slitting was getting dull and broke during machining, causing slot to be crooked and in an angle	dep. cr	Scrap and Destroy no replace qty (42)	JL 08/09/20	S 08/10/06	08.10.06	08/10/06

NOTE: Date & initial all entries

Date: Friday, 05/09/2008 10:07:52 AM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CLEVIS

Job Number: 41858

Part Number: D34531

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

MILLING CONV.

CONVENTIONAL MILLING MACHINE



Comment: CONVENTIONAL MILLING MACHINE

1- Drill as per dwg D3453

2-Deburr as per dwg D3453

MMF 08/09/27

(11)

7.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

MMF 08/09/27

(11)

(P12)

8.0

QC8

SECOND CHECK



Comment: SECOND CHECK

M.A 08/09/27

(7)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

08/10/07

(7)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/10/08


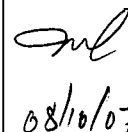
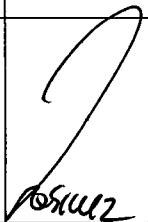
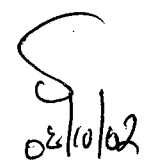
Job Completion



MF 08-10-07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3453-1 PAR #: D/A Fault Category: Prod / Machine / Parts NCR: Yes No DQA: A Date: 08/10/07
 Resolution: _____ Disposition: _____ QA: N/C Closed: LD Date: 08/10/07

NCR: 41858		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
8/10/07	60	Three (3) parts scrap Part hole is filed by 0.100" from nominal.		Scrap and Destroy no replace Qty (3)	mme 08/10/07	 08/10/07		 08/10/07
		PLC. used during Drilling						

NOTE: Date & initial all entries

2 - NCR

DART AEROSPACE LTD		Work Order: 41858
Description: Clevis		Part Number: D3453-1
Inspection Dwg: D3453	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST



☒ First Article ☐ Prototype

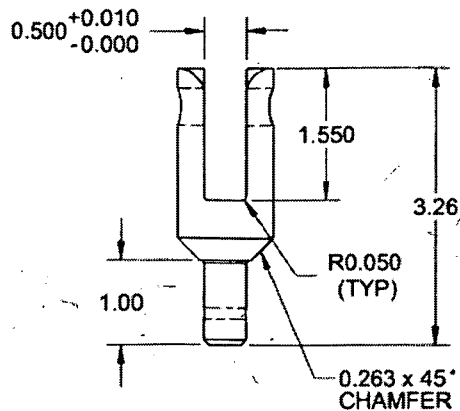
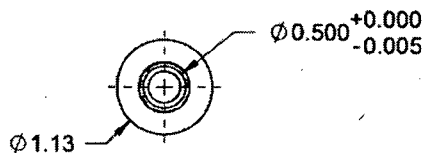
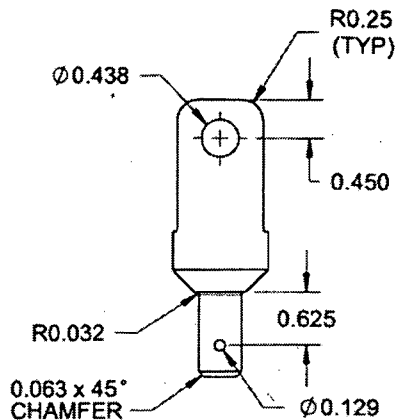
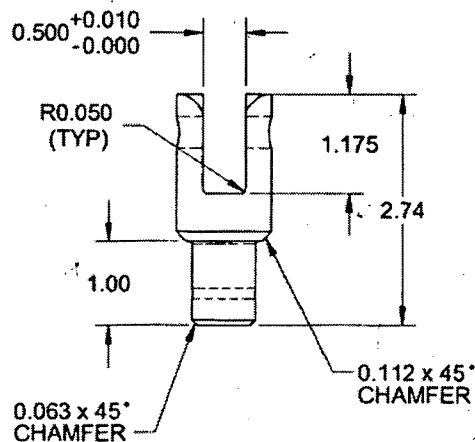
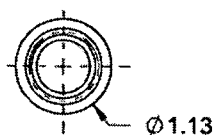
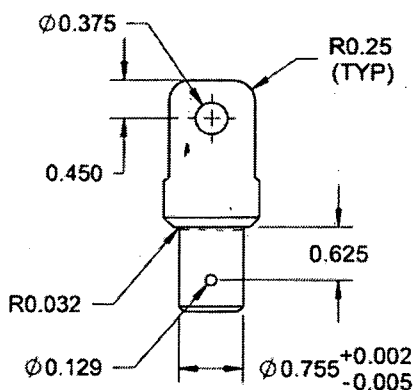

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.438	+0.006/-0.001	.438	✓			
R0.25	+/-0.030	.25	✓			
0.450	+/-0.010	.449	✓			
0.625	+/-0.010	.625	✓			
0.063 x 45°	+/-0.010 x 0.5°	.060 x 50°	✓			
Ø0.129	+0.005/-0.001	Ø.130	✓			
3.26	+/-0.030	3.260	✓			
1.00	+/-0.030	.993	✓			
1.550	+/-0.010	1.542	✓			
Ø0.500	+0.010/-0.000	.505	✓			
0.263 x 45°	+/-0.010 x 0.5°	.263 x 45°	✓			
Ø1.13	+0.012/-0.001	Ø1.128	✓			
Ø0.500	+0.000/-0.005	Ø.494	✓			

Measured by: SD J.L.	Audited by: H.A.	Prototype Approval:	N/A
Date: 08/09/16	Date: 08/09/27	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	06.06.30	New Issue	KJ/JLM	
B	07.01.17	Dimensions added	KJ/JLM	

DART

DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 	APPROVED 	DRAWING NO. D3453	REV. A SHEET 1 OF 2
DATE 05.09.02		TITLE CLEVIS	SCALE 1:2
A	05.09.02	NEW ISSUE	

**D3453-1 CLEVIS****RELEASED**05.12.09 **D3453-3 CLEVIS****NOTES:**

- 1) MATERIAL: AISI 304 SS ROUND BAR (REF. DART SPEC M304R)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010

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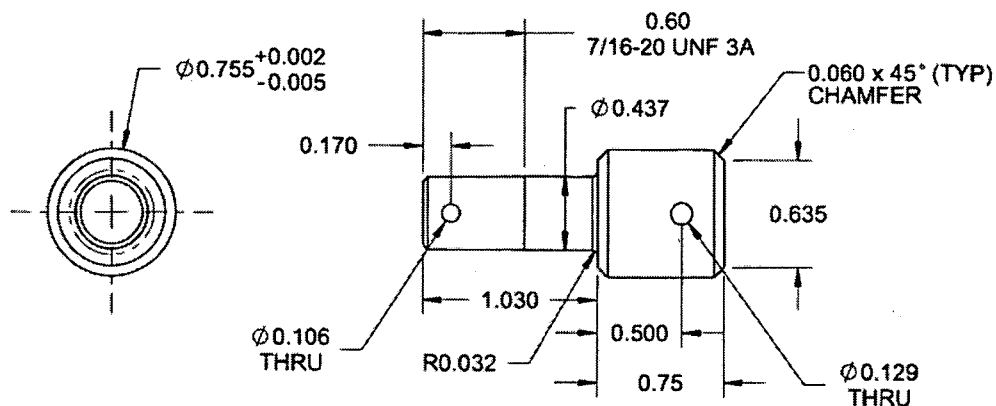
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CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3453	REV. A SHEET 2 OF 2
DATE 05.09.02		TITLE CLEVIS	SCALE 1:1

RELEASED

05.12.09 [Signature]



D3453-5 PLUG

NOTES:

- 1) MATERIAL: AISI 304 SS ROUND BAR (REF. DART SPEC. M304R)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010

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